



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

13173

D350-636-024
Job Sheet 189950



Part No: D350-636-024

Job Qty: 1 ea

Part Name: AS350/355 - Skid tubes - Standard w/ Heavy-Duty Wearplates - RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/1/19

Job Tracking No:

Due Date: 2/8/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: D4168-052 REV.C, IIN-D350-636 REV.K IPP REV.A 18.11.29 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials



Container No: S150918



Part: D350-636-024

Job No: 189950

Serial No/Batch: S150918

Revision: C/K

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

CANADA

TEL: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 02/05/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/8/19	0.00	0.00	Start Up Skid tubes-1		BE
110	Skid tubes	1 pcs		2/8/19	0.00	4.78	Skid tubes-1		BE
120	QC	1 pcs		2/8/19	0.00	0.00	QC10		PD 19-02-03
130	QC	1 pcs		2/8/19	0.00	0.00	QC5		PD 19-02-03
140	HandFinish	1 pcs		2/8/19	0.00	0.98	HandFinish1		D.R. 19/2/12
150	QC	1 pcs		2/8/19	0.00	0.00	QC7-2		BE
160	Skid tubes	1 pcs		2/8/19	0.00	4.78	Skid tubes-1		DO BE
170	QC	1 pcs		2/8/19	0.00	0.00	QC10		EL
180	QC	1 pcs		2/8/19	0.00	0.00	QC5		MAR 2 6 2019
190	HandFinish	1 pcs		2/8/19	0.00	0.98	HandFinish2		D.R. 19/03/26
200	SprayPaint	1 pcs		2/8/19	0.00	0.61	Spray Paint		RD 19-4-7
205	Outsource	1 pcs		2/8/19			ATE003-VC	5	NR
210	QC	1 pcs		2/8/19	0.00	0.00	QC14		BE
230	HandFinish	1 pcs		2/8/19	0.00	0.98	HandFinish4		M 19-02-03
240	QC	1 pcs		2/8/19	0.00	0.00	QC5		DAS
250	Packaging	1 pcs		2/8/19	0.00	0.00	Packaging1-3		DAS
260	QC	1 pcs		2/8/19	0.00	0.00	QC4		21
270	Packaging	1 pcs		2/8/19	0.00	0.00	Packaging3-1		9-89
275	DC	1 pcs		2/8/19	0.00	0.00	DC		21
280	QC21-FG	1 Ea		2/8/19	0.00	0.00	QC21		21

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
 Descriptions: D4168-6 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168 (D4168-6 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section DK-DK and open to 0.500" 5- Drill tow ring hole using DT9616 detail "DF" 6- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole 7- Open up holes of Detail DF to 0.297" (total of 2 holes per side) +.201" (total of one hole per side DT9616) as per dwg D4168. 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch:
 136158/ 138189 9- Grind welds flush as per Dwg D4168
 160 - 1-Open up holes using hole saw of Detail DG and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168. 4-Chamfer holes of Detail DG, ground handling and float holes per dwg D4168 (welding instructions on sheet) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 513833 exp. date: 03/07/19 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D2743 as per dwg D4168 & QSI004 (welding instructions on sheet) A/R Aluminum Rod batch: 138189 10-Grind welds flush as per Dwg D4168 11-Spot face ground handling holes section ES-ES (total of 4 places per side) as per dwg D4168 12- C'bore section ET-ET. ADJUST TOOLING AS REQUIRED. VERF BY: 13- Deburr holes, ensure tube is free of all scratches before sending to paint. ***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE *****
 *****REF TO W/O BATCH:*****
 180 - ***VERIFY C'BOARD IS GOOD***
 190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
 200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5152590 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5156021
 210 - Inspect for foreign object per QSI 024
 230 - 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-4, wearshoes and ground handling hardware as per dwg D4168 SIKAFLEX 241 BATCH: 5163445 EXP DATE: 19/04 5- Coat all exposed fasteners with "LPS Procyon" batch: M133690
 250 - If making a D350-636-216 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A
 260 - *****ensure antiseize is on AN8C21A bolts*****
 270 - Identify and pack for shipping as per PPPD350-636-024 Location : FG071
 275 - record fwd angle: 89.8 Photocopy blue file and type labels per PPP D350-636-024 CHG 001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 pcs (1 ea)	90-Start up Operation	5129559
D2744	Cap	1 pcs (1 ea)	90-Start up Operation	5060499
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes	5152441
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes	5156521
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-HandFinish	5059809
AN3C34A	Bolt	1 Ea (1 ea)	230-HandFinish	5117121
AN3C36A	Bolt	4 Ea (4 ea)	230-HandFinish	FM136658-1
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5142453
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	5149188
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	5079137-1
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5163736
D3488-4	Blade Fitting, RH	1 pcs (1 ea)	230-HandFinish	5148185
D3631-1	Washer	8 pcs (8 ea)	230-HandFinish	5058407
D3873-1	Bushing	7 pcs (7 ea)	230-HandFinish	5154066 / 5172571
D4154-041*	Wearplate Assembly	1 Ea (1 ea)	230-HandFinish	* 5178113
D4170-1	Bushing	4 pcs (4 ea)	230-HandFinish	5137508
D4171-1	Bushing	1 pcs (1 ea)	230-HandFinish	5142731
MS21043-3	Nut	5 Ea (5 ea)	230-HandFinish	5099569
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5149193
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5104046-1
NAS1149C0332R	Washer	4 Ea (4 ea)	230-HandFinish	5148669
NAS1149C0363R	Washer	9 Ea (9 ea)	230-HandFinish	5135100
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	5076017-2
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5083559
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging	5162124
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	5176381
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging	5129318
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5167203
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	5166719

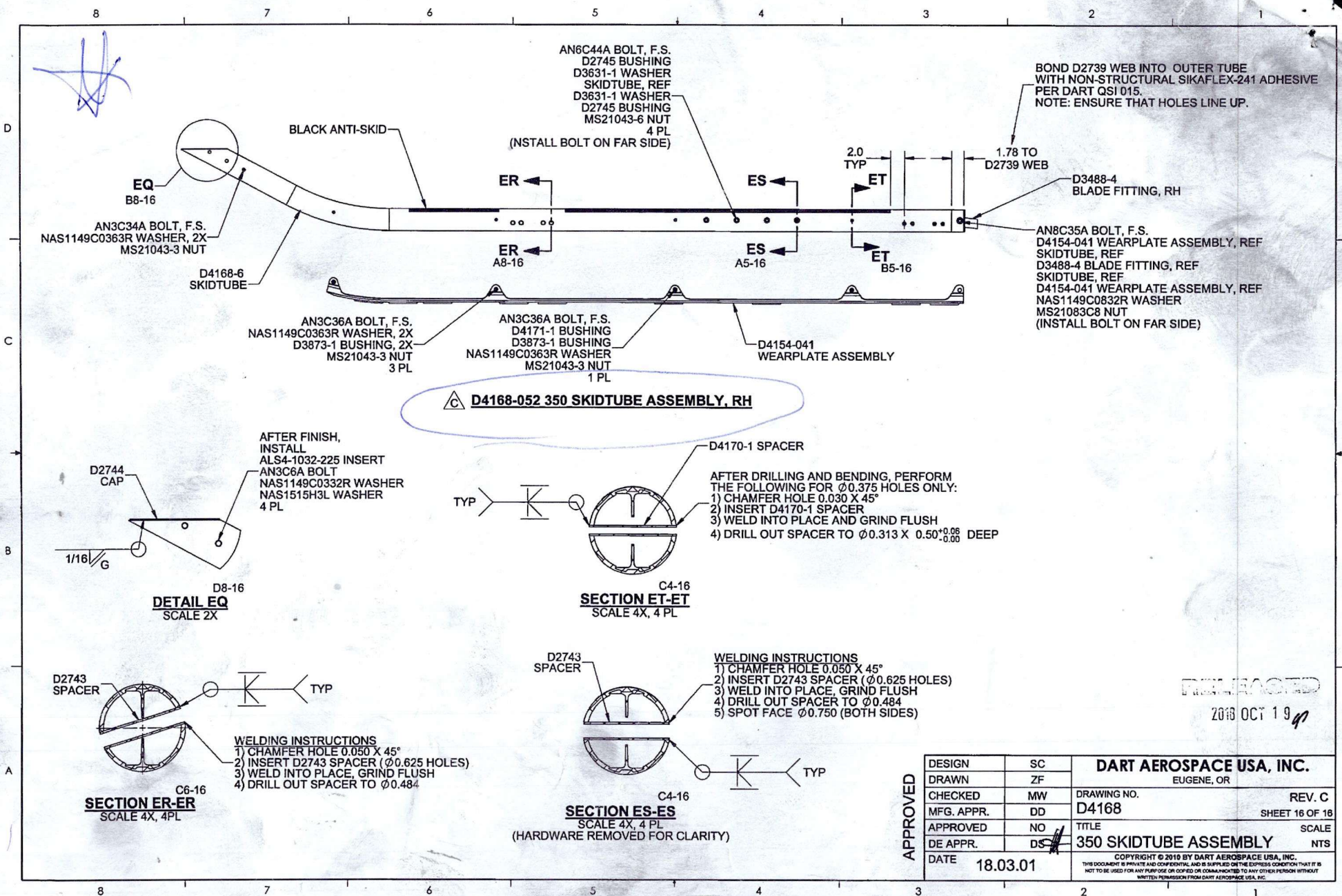
M.4.009172.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-RH	1	6	0
	D2744	1	1	0
160-Skidtubes	D2739	1	4	0
	D2743	8	16	0
230-HandFinish	ALS4-1032-225	4	709	0
	AN3C34A	1	10	0
	AN3C36A	4	384	0
	AN3C6A	4	172	0
	AN6C44A	4	103	0
	AN8C35A	1	30	0
	D2745	8	106	0
	D3488-4	1	9	0
	D3631-1	8	305	0
	D3873-1	7	12	0
	D4154-041	1	6	0
	D4170-1	4	42	0
	D4171-1	1	14	0
	MS21043-3	5	1,390	0
	MS21043-6	4	171	0
	MS21083C8	1	47	0
	NAS1149C0332R	4	5,027	0
	NAS1149C0363R	9	651	0
	NAS1149C0832R	1	351	0
	NAS1515H3L	4	402	0
250-Packaging	AN3C37A	1	35	0
	AN8C21A	2	55	0
	D2741	1	49	0
	MS21083C8	2	47	0
	NAS1149D0863J	2	125	0

Part Specifications
Specifications could not be found.

Plex 2/1/19 9:20 AM Dart.Macdonald.Dara



Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

Change Record

PAGE 1 OF 1

Part Number: D350-636-023/-024

Description: SKIDTUBE INSTALLATION LH/RH, STD COMPATIBLE W/TRAINING WEARPLATE

[illegible]